

Date: Friday, 10/20/2006 1:05:13 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 28950	
Estimate Number : 12551	
P.O. Number : <i>N/A</i>	Part Number : D34521
This Issue : 10/20/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3452 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/12/2006 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/19/2006 Qty: <i>12</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est A 06.10.11 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0579 sf(s)/Unit Total : 0.5786 sf(s)
 Material: 6061-T6 0.080" Thick
 Batch *H101178*

2.0	WATER JET	FLOW WATER JET
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 FLOW WATER JET
 1-Cut as per Dwg D3452
 Dwg Rev: *A*
 Prog Rev: *A*

2-Tumble, Deburr if necessary

SAD 06:10:14 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:10:14 12

4.0	QC8	SECOND CHECK
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 SECOND CHECK

2006-10-16

Date: Friday, 10/20/2006 1:05:13 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28950

Part Number: D34521

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

5.1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
SMALL & MEDIUM FAB RESOURCE 1

1-bend per dessin D3452

JB 06/10/25

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

Y

06/10/26 x 12

7.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y

06/10/26 x 12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/27 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
PACKAGING RESOURCE #1
Identify and Stock
Location:

06/10/27 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
FINAL INSPECTION/W/O RELEASE

06/10/27

Job Completion



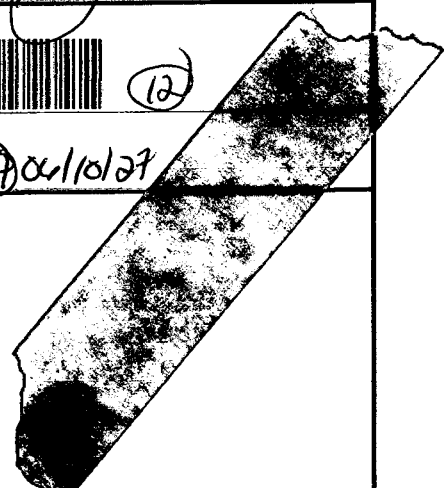
06/10/27

06-10-25

5.2

QC5
Inspect Rev.

06-10-25

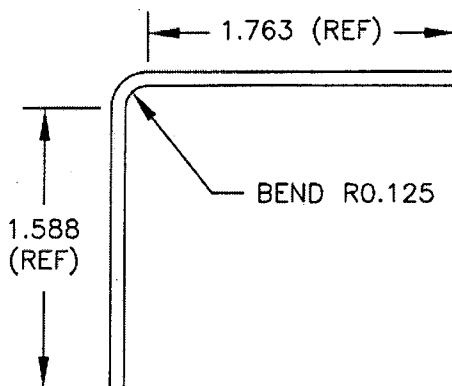
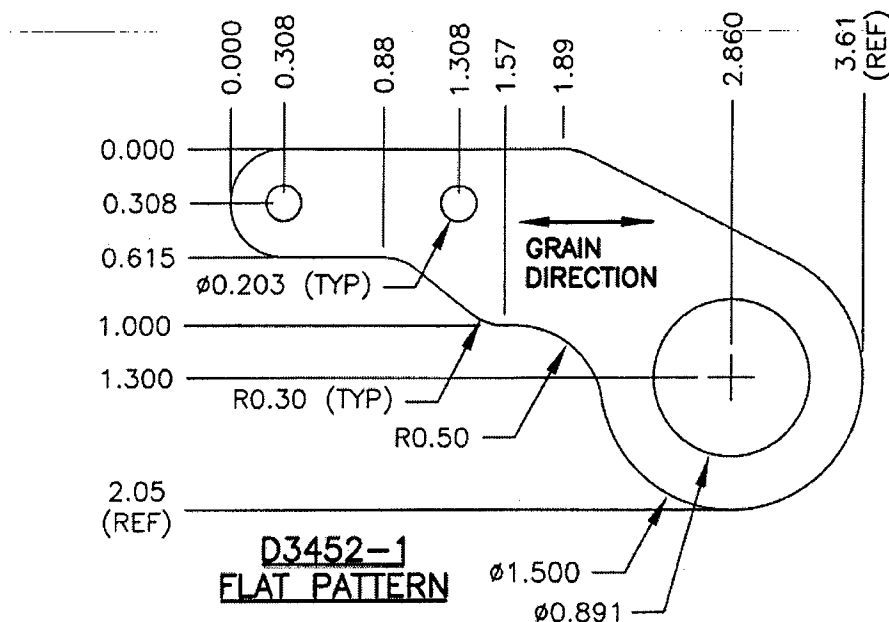
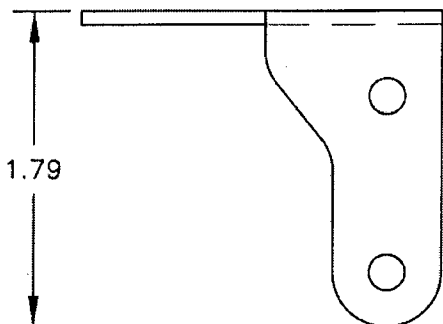
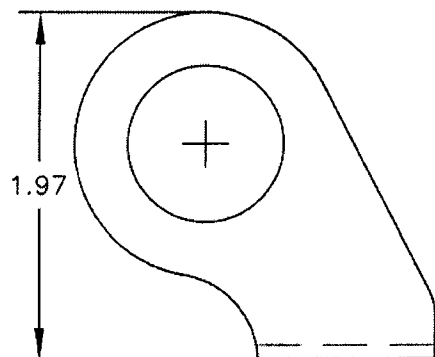


DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3452	REV. A SHEET 1 OF 2
DATE 05.08.30		TITLE BRACKET	SCALE 1:1
A	05.08.30	NEW ISSUE	

RELEASED

05.09.12 #

**D3452-1 BRACKET**



- 1) MATERIAL: 6061-T6 SHEET, 0.080" THICK (REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

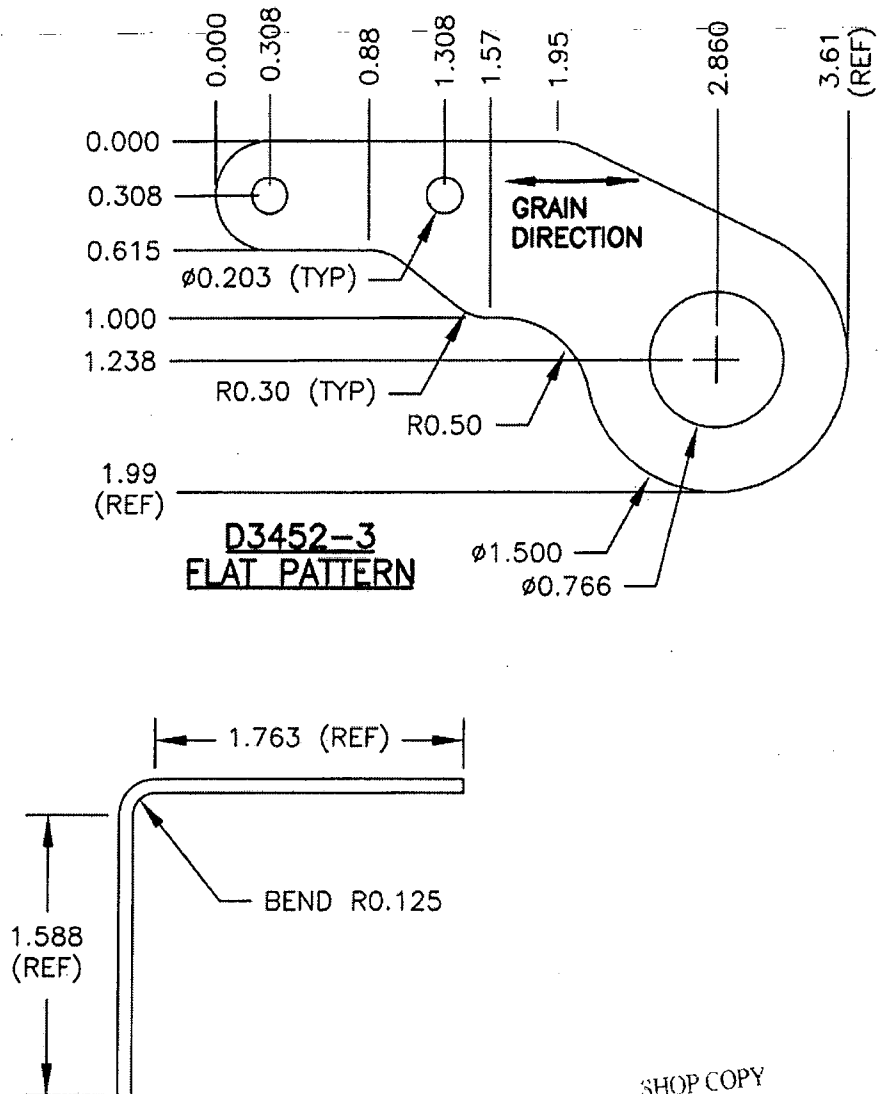
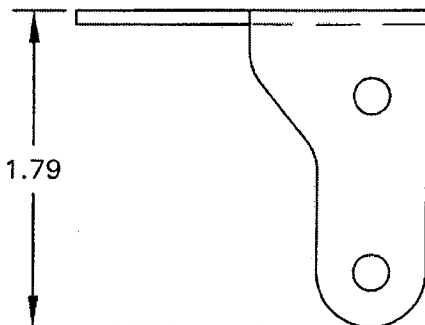
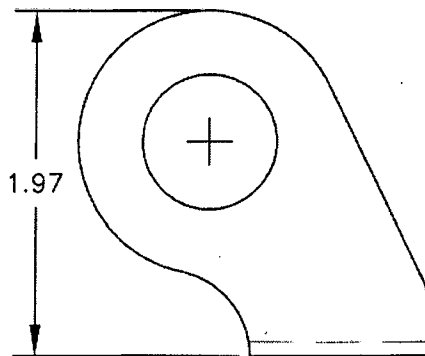

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3452	REV. A SHEET 2 OF 2
DATE 05.08.30		TITLE BRACKET	SCALE 1:1

RELEASED05.04.12 **D3452-3 BRACKET**

- 1) MATERIAL: 6061-T6 SHEET, 0.080" THICK (REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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